

Date: Monday, 11/19/2007 4:05:38 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	STEP WELDMENT		
Job Number	35869			Part Number	D2563		
Estimate Number	10176			Drawing Number	D2563 REV C		
P.O. Number	:			Project Number	N/A		
This Issue	11/19/2007	S.O. No.	:	Drawing Revision	C		
Prsht Rev.	NC			Material	:		
First Issue	11/19/2007	Type	LARGE FAB ASSY	Due Date	11/29/2007	Qty:	2
Previous Run	35153A			Um:	Each		
Written By	:						
Checked & Approved By	JF 07.11.20						
Comment	Est Rev 0 02.07.31 Re-format Location RF						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D2244116	Step Extrusion		
		 <b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) <b>Pick:</b> 1 D2244 Step Extrusion <b>Batch:</b> 333733		
2.0	D267334	End Plate		
		 <b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) <b>Pick:</b> Qty Part No. Description Batch 2 D2673-34 End Cap 332404		
3.0	D2561	Lug Plate		
		 <b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) <b>Pick:</b> Qty Part No. Description Batch 2 D2561 Lug Plate 334357		
4.0	D2564	Mounting Angle		
		 <b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) <b>Pick:</b> Qty Part No. Description Batch 2 D2564 Mounting Angle 335959		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 35869

Part Number: D2563

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

11/09/2007 2

2-Deburr ends

11/09/2007 2

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

A/R AL ROD Batch: M105058  
M105844

11/09/2007 2

4- Grind

a.m.

07/11/2007

6.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/09/2007 2

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/09/2007 2

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07/09/2007 2

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11/09/2007 2

10.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

11/09/2007 2

1-Inspect for foreign object per QSI 024

11/09/2007 2

2-Weld Remaining End as per Dwg D2563 using DT 8343

11/09/2007 2

A/R AL ROD Batch: M105058

3-Grind

11/09/2007 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:05:39 PM  
User: Kim Johnston

## Process Sheet

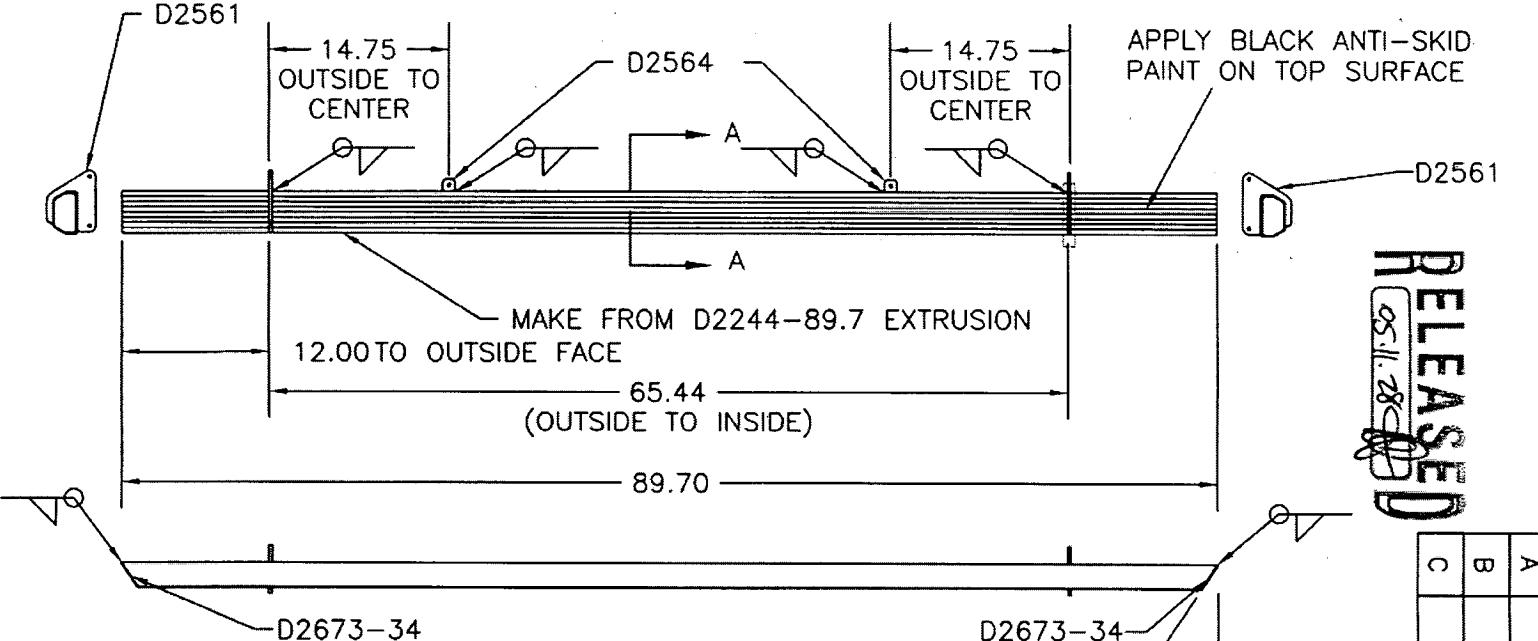
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: STEP WELDMENT
Job Number: 35869		Part Number: D2563
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
11.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		PD 07-11-27 (2)
12.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		L 07/1/27 (2) 
13.0	POWDER COATING 	POWDER COATING <b>M 105914</b> 
Comment: POWDER COATING Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		touch up alodine - Ex 07/11/27 <b>M. J. 07/11/27</b>
14.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 <b>M 106030</b> 
Comment: HAND FINISHING RESOURCE #1 Wing Walk as per Dwg D2563 and QSI 005 4.4		YJ 07-11-28 (2) 
15.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION <b>PPP B35868</b> 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		L 7/14/28 (2)
16.0	QC21 	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		07.11.28 (2)
Job Completion 		u 07.11.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D2563 STEP WELDMENT ASSEMBLY PARTS LIST**

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

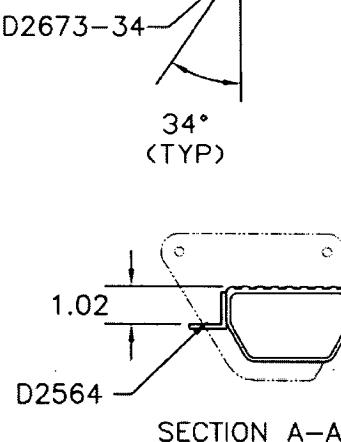
\*cut per drawing

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35869

**D2563 STEP WELDMENT ASSEMBLY NOTES**

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE  
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
05.11.28.00



DESIGN BW	DRAWN BY PP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED H	APPROVED H	DRAWING NO. D2563	SHEET 1 OF 1
DATE 05.11.14	TITLE STEP WELDMENT ASSEMBLY	SCALE 1:15	
A	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	